

Date: Tuesday, 10/24/2006 10:54:28 AM
 User: Kim Johnston

Process Sheet

Split-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29120
 Estimate Number : 10386
 P.O. Number : N/A
 This Issue : 10/24/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 25849
 Written By :
 Checked & Approved By : J 06 10 24
 Comment : Est Rev: A New Issue 05-11-08 JLM

Drawing Name : BAR
 Part Number : D3196-2
 Drawing Number : D3196 UNDER REVIEW 06.10.24
 Project Number : N/A
 Drawing Revision : U/R
 Material : N/A
 Due Date : 11/10/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .75" X 1.5"



Comment: Qty.: 2.2922 f(s)/Unit Total: 11.4608 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-1
 Batch: 17102947

J.F. 06/10/29

5

2.0 BAND SAW BAND-SAW



Comment: BAND SAW
 Cut blank: (0.75" x 1.50") x 26.200" long Bar

J.F. 06/10/29

5

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1

2-Deburr

J.F. 06/10/31

5

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/10/31

5

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06.10.31

Tuesday, 10/24/2006 10:54:29 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 29120

Part Number: D31961

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Y 06/11/01 x 5

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 19720

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.A. 06/11/02 (5)
07/01/16

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/01/16 (2)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

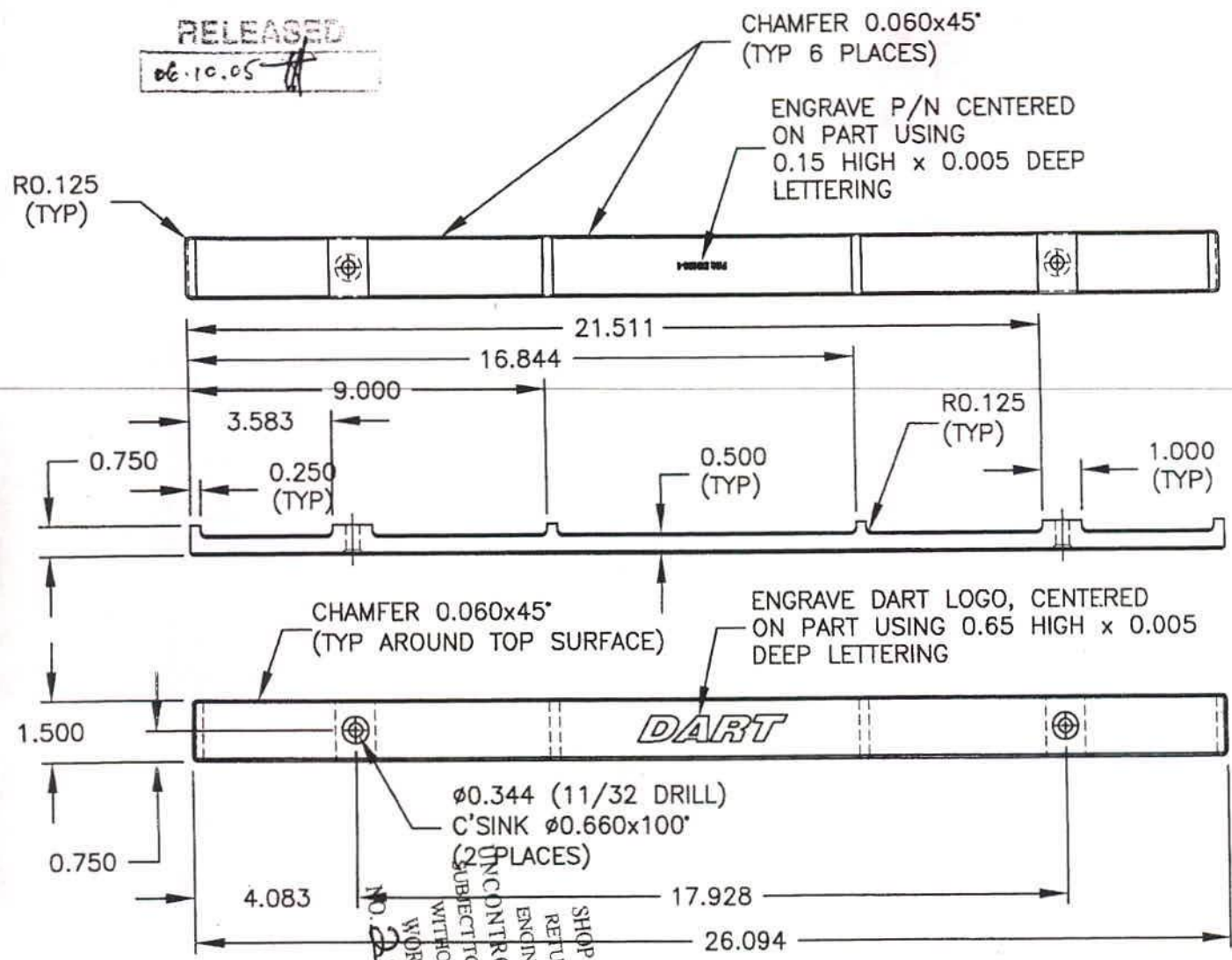
07/01/17 (2)

Job Completion



C207101117

DART



DESIGN	CP	DRAWN BY	JB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	JB	APPROVED	JB	REV. B
DATE	06.09.25	DRAWING NO.	D3196	SHEET 1 OF 4
		TITLE	BAR	SCALE
				1:4
A	03.06.25	NEW ISSUE		
B	06.09.25	ADD D3196-5		

D3196-1 BAR

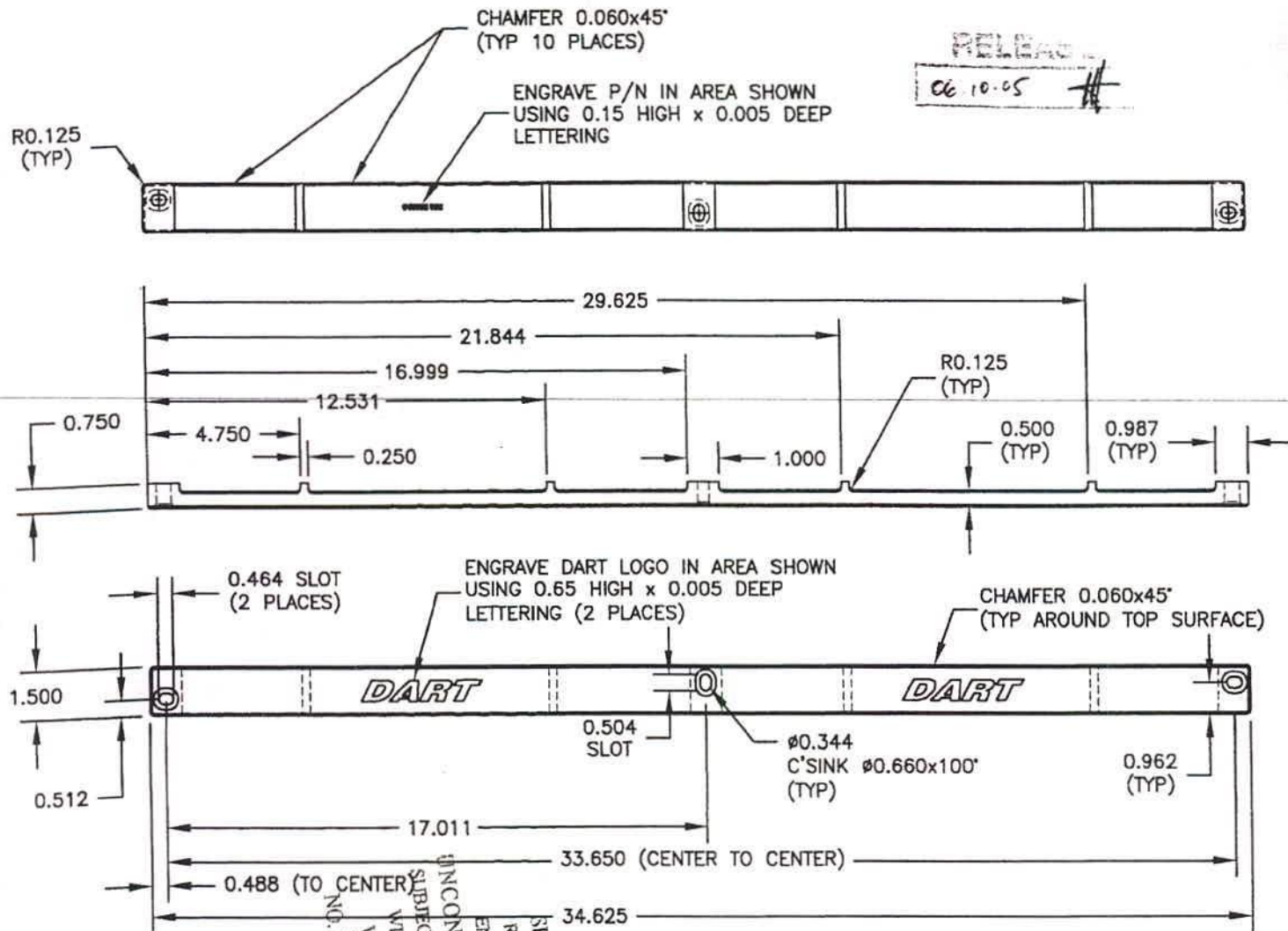
- 1) MATERIAL: 6061-T6/T651 ALUMINUM 109-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

NO. 2120
WORK ORDER
SUBJECT TO AMENDMENT
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DART



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

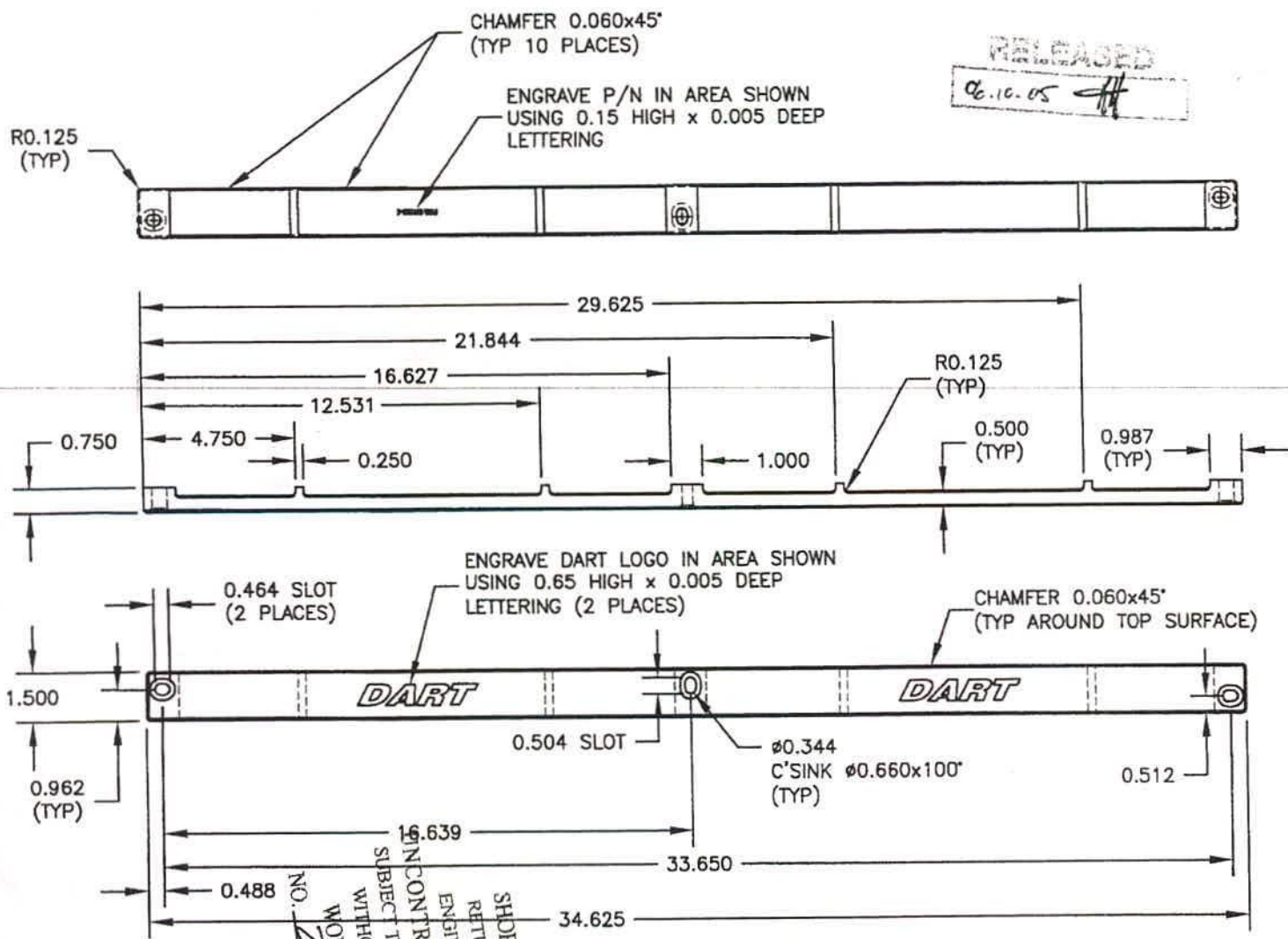
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DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3196	SHEET 2 OF 4
DATE	TITLE	SCALE	
06.09.25	BAR	1:5	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DART

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DATE	DRAWING NO.	REV. B
06.09.25	D3196	SHEET 3 OF 4
	TITLE	SCALE
	BAR	1:5



D3196-4 BAR

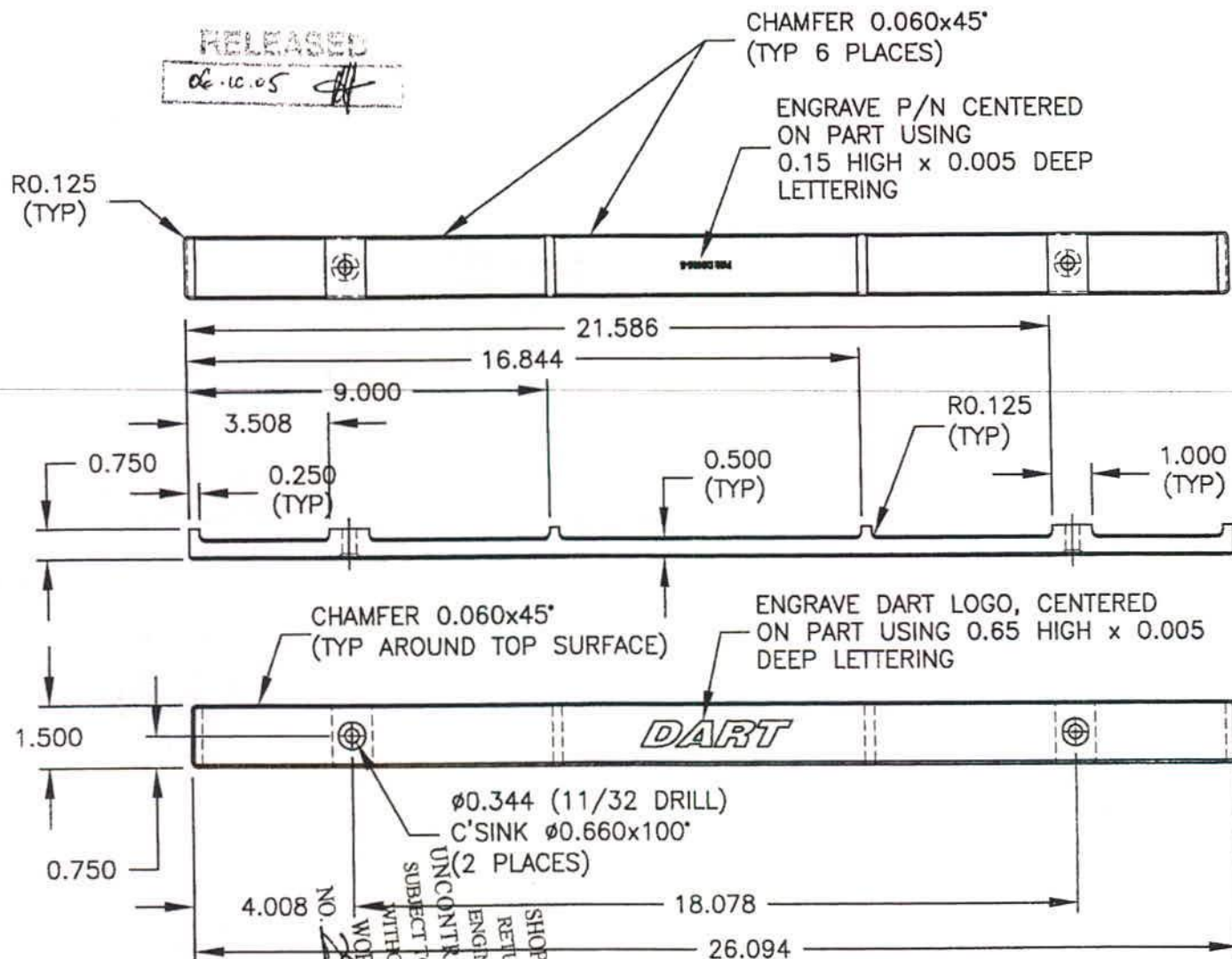
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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06.09.25	D3196	SHEET 4 OF 4
	TITLE	SCALE
	BAR	1:4



D3196-5 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES